

Date: Wednesday, 11/7/2007 8:18:52 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35597		
Estimate Number	: 11028		
P.O. Number	: N/A	Part Number	: D28022
This Issue	: 11/7/2007	Drawing Number	: D2802 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 29688	Material	: N/A
Written By	<u>JL 07-11-07</u>		
Checked & Approved By			
Comment	Est:B 02.03.18 Re-format NG Est:C 06.02.13 Removed p/c EC		

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
		
Comment: Qty.: 1.5750 f(s)/Unit Total : 42.6000 f(s) 6061-T6 Bar .50" x 6.0" 14.175 Material: 6061-T6 bar 6.00" x 0.50" Batch: M106027X4 M 105145 X 5 JNL 07/11/07 (9)		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks 17.800" long JNL 07/11/07 (9)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg JNL 07/11/10 9		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE JNL 07/11/10 9		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK JNL 07-11-10 (9)		

Date: Wednesday, 11/7/2007 8:18:52 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35597

Part Number: D28022

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr NO sharp edges.

OK 07/11/12 (9)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

OK 07/11/12 (9)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WTF*

OK 07-15-15 (9)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

OK 07-15-15 (9)

Job Completion



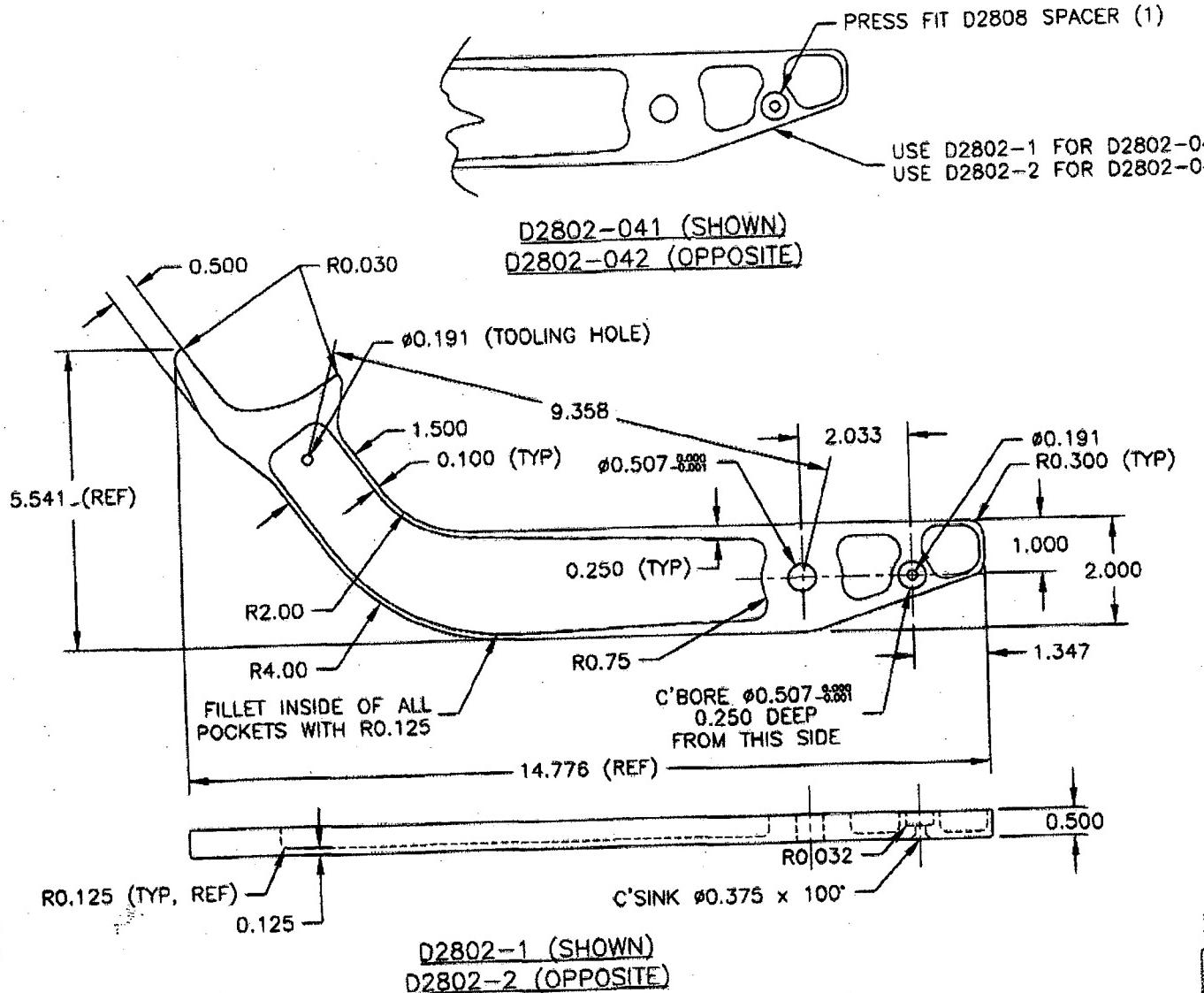
OK 07-15-15

DART

© DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
G.P.	J.H.	D2802
DATE	TITLE	SCALE
00.11.03	ARM	1:3

RELEASED
00-41-13
4



MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	
Description: Arm	Part Number:	D2802-2
Inspection Dwg: D2802 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.F.	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/11/09	Date:	<i>07/11/10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	JL